

6061 .500X .044 W

Work Order ID 165397

165397

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Monday, August 21, 2017 2:56:27 PM

Item ID: D3490-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Cross Bolt Spacer
Start Date: 8/18/2017 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 8/23/2017 Req'd Qty: 20.00 *20* Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: AUG 22 2017 Tooling: _____ Date: _____ Run Start *NR1*
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3490	Rev A

100	Hardinge CNC LATHE SMALL	0.22				22	Ø		DAS 23 9-89 17/9/25
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100

Hardinge

Hardinge CNC Lathe Small

Memo

1-TURN AS PER FOLIO FA628 & DWG D3490

FOLIO REV: A

DWG REV: 44

2-DEBURR AS REQUIRED

110	QC2- Inspect parts off machine FAI/FAIB	0.00				22	Ø		DAS 23 9-89 17/9/25
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110

QC

Quality Control

Memo

120	QC8- Inspect parts - second check	0.00				22	Ø		mf 17/09/26
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120

QC

Quality Control

Memo

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG001</u>	0.00				<u>22</u>	<u>0</u>	<u>BE</u>	<u>17-09-27</u>
130									
Packaging	Memo	0.20							
Packaging	CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER								
	STOCK IN SKIDTUBE CELL								
	LOCATION : LG001								
140	QC21- Final Inspection - Work Order Release	0.00							<u>17/9/27</u>
140									
QC	Memo	2.00							
Quality Control									

DAS
21
9-89um 17/9/27

Picklist Print

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Work Order ID: 165397

165397

Parent Item: D3490-1

D3490-1

Parent Item Name: Cross Bolt Spacer

Start Date: 8/18/2017

Required Date: 8/23/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	69.6768	0.266	5.6			
M6061T6T0 500W 049									**				
6061-T6 RD Tube .500 x.049W													

Location

Loc Qty

Loc Code

MAT013

69.676842

69.676842

mt31932

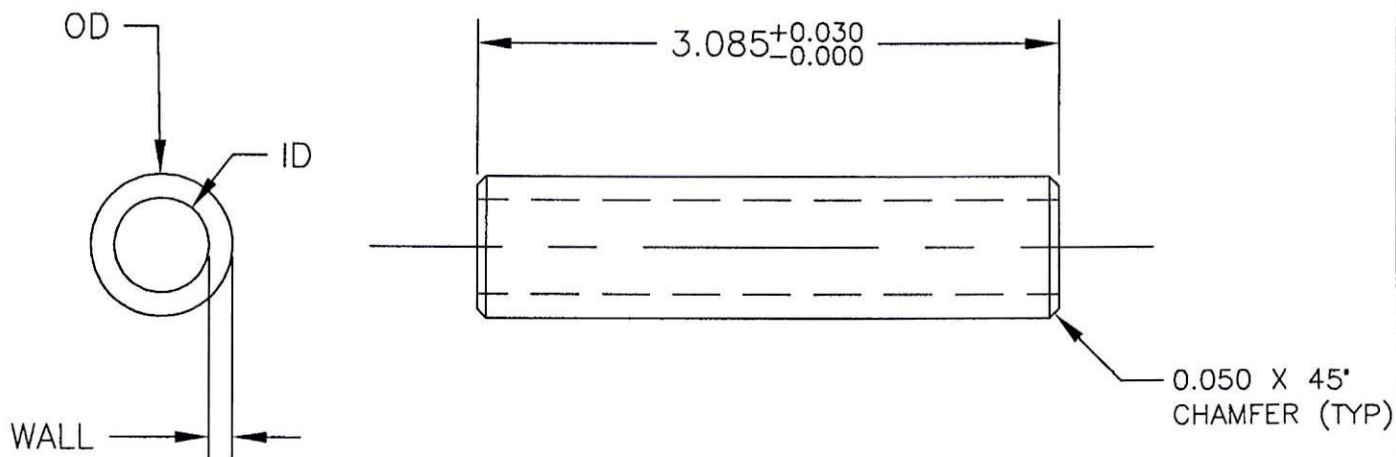
6.4375

DAS
23
9-89

17/9/25



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1 ←	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

170822
NO. 165397
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
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ENGINEERING
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06-02-07

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